

Date: Thursday, 15/01/2009 11:13:21 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACER
Job Number : 44780	
Estimate Number : 11167	
P.O. Number :	Part Number : D32783
This Issue : 15/01/2009 S.O. No. :	Drawing Number : D3278 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 43448	Material :
Written By :	Due Date : 30/01/2009 Qty: 40 Um: Each
Checked & Approved By : <u>STU OA 01.15</u>	
Comment : Est. A 04.04.19 New issue KJ/JLM Est B 07.09.06 Rev C dwg EC Verified by: JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MDELRLINS0125	Black Delrin Sheet .125
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Comment: Qty.: 0.0361 sf(s)/Unit Total : 1.4448 sf(s)

Black Delrin

Material: Black Delrin/UHMW 0.125" thick

(M-DELRIN-S0.125x30.0)

Identify for D3278-3

Batch: 15607

IB 9-1-31

IB 9-1-27

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3278

Dwg Rev: CProg Rev: C

2-Deburr if necessary

IB 9-1-31
IB 9-1-27

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINEIB 9-1-31
IB 9-1-27

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

Solder 27 counter
 +66

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

NOTE: Date & initial all entries

Date: Thursday, 15/01/2009 11:13:21 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 44780

Part Number: D32783

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



(P70)

Comment: SMALL & MEDIUM FAB RESOURCE 1
1-C'sink as per dwg D3278

2-Deburr

09/02/02

(86)

6.0

QC5

INSPECT WORK TO CURRENT STEP



counters

Comment: INSPECT WORK TO CURRENT STEP

Sorter 02 (86)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



96/2

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: 87

50

(88x)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/03

Comment: FINAL INSPECTION/W/O RELEASE


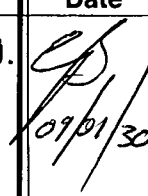
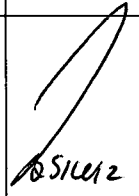
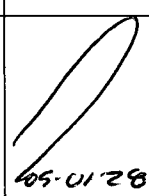
Job Completion



MF 09-02-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3278-3 PAR #: WHT Fault Category: Prod / Fin. ass. med / for NCR: (Yes) No DQA: D Date: 09/02/03
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: D Date: 09/02/03

NCR: <u>44780</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				
09-01-28	5.0	C'sink is too deep on 39 parts. Scrap. Set stop was moved during work. The first 6-10 were checked.		Scrap & replace qty 39. N <u>15607</u> Replaced with 61 parts	 09/01/30	S 09/02/02	 05/01/02	 05-01-28
		RC: process						

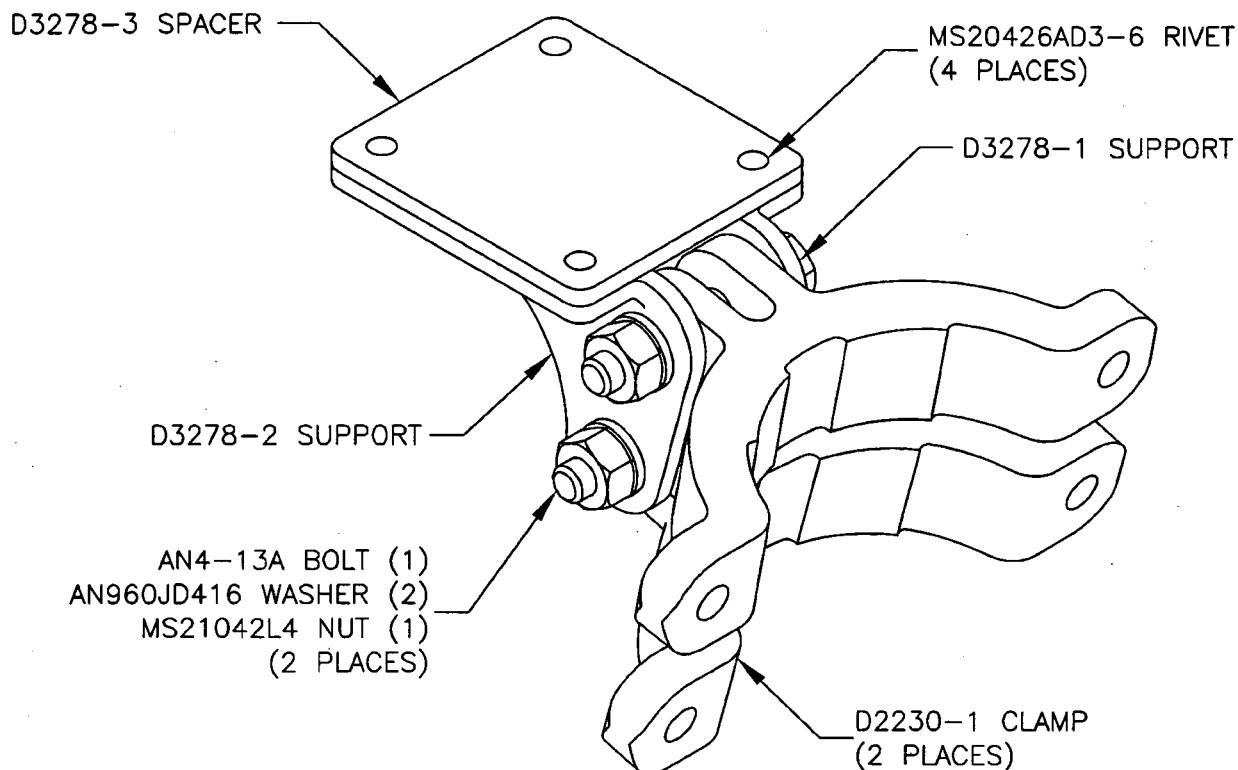
NOTE: Date & initial all entries



DESIGN 97	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07-08-06

D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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NO. 64780

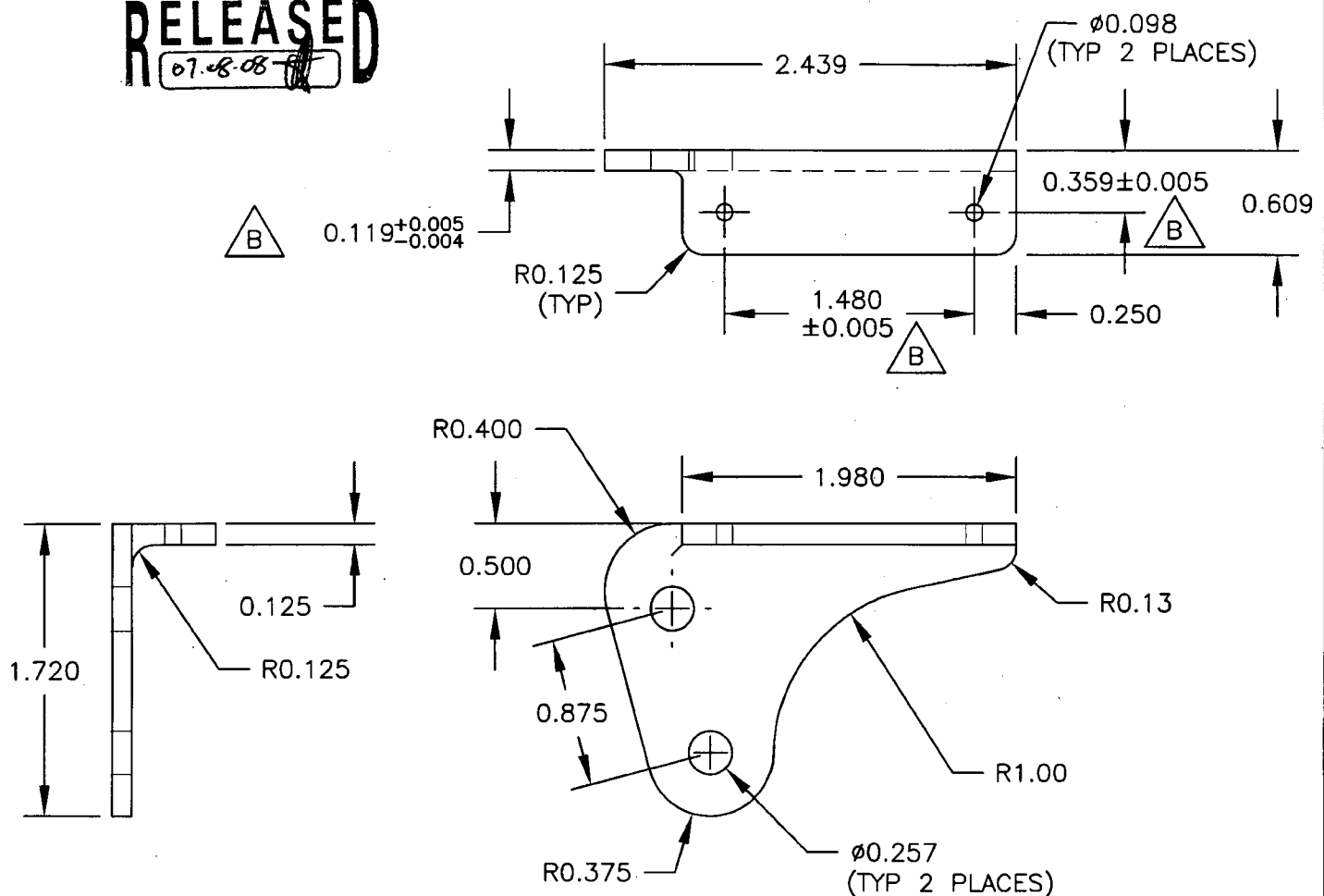
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08



D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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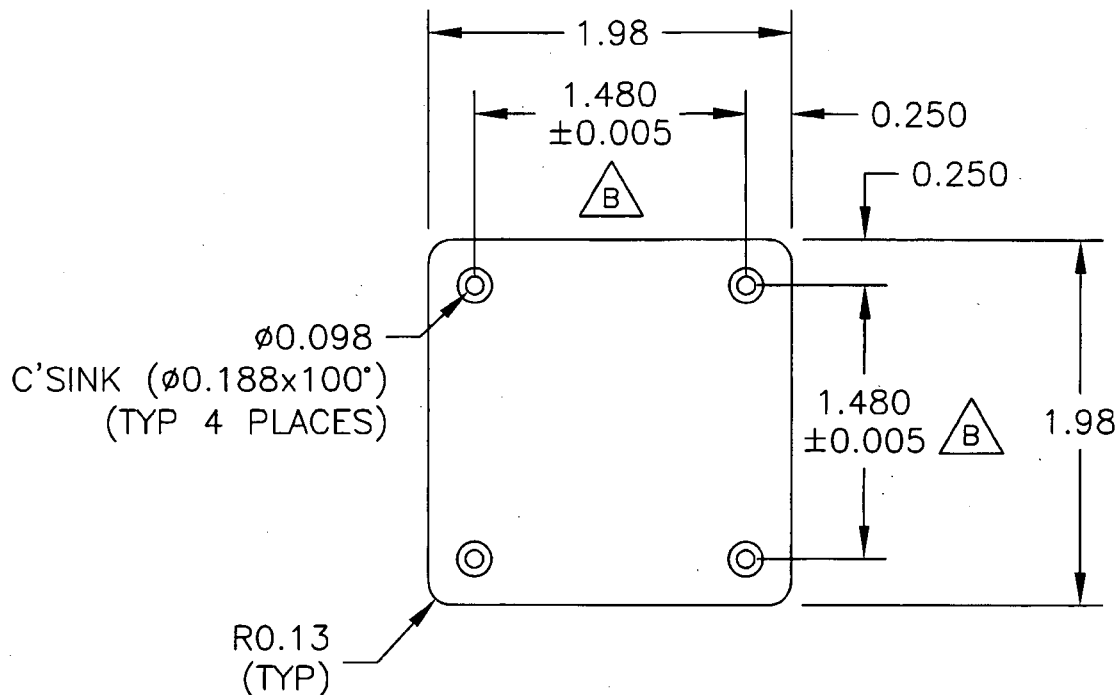
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CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08



D3278-3 SPACER

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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